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5116545

D119-796-251
Job Sheet 183802



Part No: D119-796-251

Job Qty: 1 ea

Part Name: Aft Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP
REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD IPP
REV:F 17.12.11 REMOVE PACK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/31/18	0.00	0.00	Start Up Crosstubes-1		AS OCT 07 2018
130	Crosstubes	1 pcs		10/31/18	0.00	0.51	Crosstubes-1		AS OCT 07 2018
140	QC	1 pcs		10/31/18	0.00	0.00	QC5		38
142	Packaging	1 pcs		10/31/18	0.00	0.00	Packaging1-6		N/R
143	QC	1 pcs		10/31/18	0.00	0.00	QC4		N/R
145	DC	1 pcs		10/31/18	0.00	0.00	DC		N/R
150	Packaging	1 pcs		10/31/18	0.00	0.00	Packaging3-1	LG050	AS OCT 07 2018
160	QC21-FG	1 Ea		10/31/18	0.00	0.00	QC21		21 OCT 09 2018

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 ***Torque all clamps to 50 IN-LBS max.***

Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***

145 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 004

150 - Identify and pack for shipping as per PPP D119-796-251

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-241	Aft Crosstube Installation Without Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 Ea (4 ea)	90-Start up Operation	
D5149-043	Aft Step Base Assembly	2 Ea (2 ea)	90-Start up Operation	
MS21920-25	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-241 5113801	①	3	0
	D5123-3 F160079	④	289	0
	D5149-043 5109821	② 5109821	7	0
	MS21920-25 5107731	④	219	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



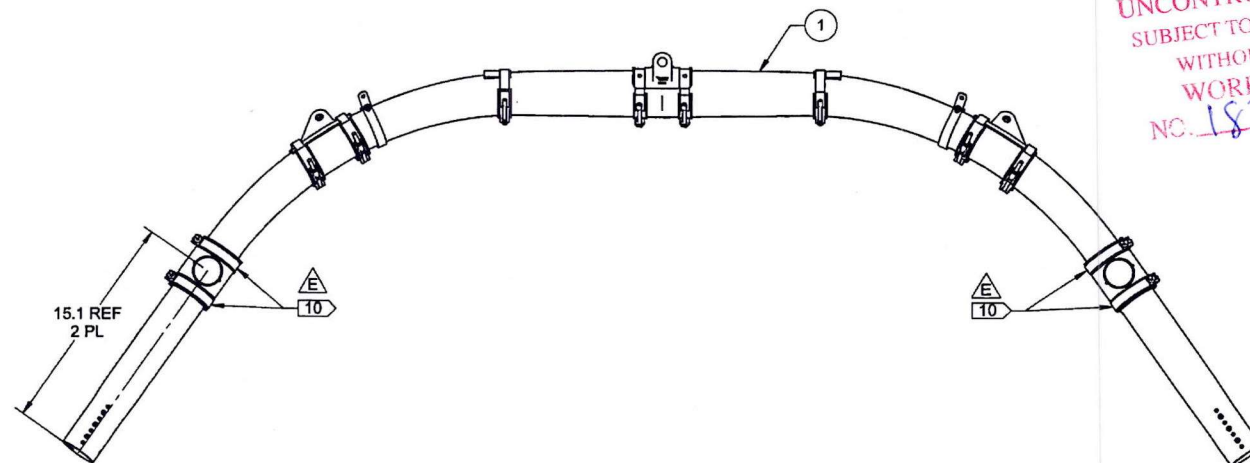
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

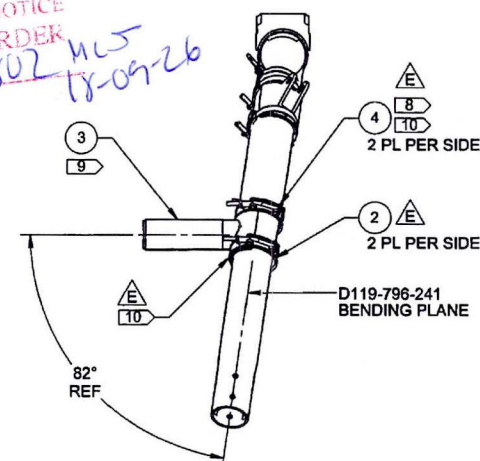
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM	QTY -251	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183802 ML5
18-09-26



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
- 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN.
THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10, REMOVED SECTION A-A (PAR18-527)	ML	17.02.10
D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-251 TITLE XTUBE ASSY (AW119 MKII AFT) DATE 17.02.10	
DRAWN	ML		
CHECKED	NO		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	REV. E	SHEET 1 OF 1
		SCALE	NTS
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RELEASED
2017-05-04
ECN 17-538

APPROVED